

Claims

1. A method for the production of piston-type accumulators having an accumulator housing (10) and a separating piston (12) displaceable in the longitudinal direction in the accumulator housing (10) which separates two working chambers (16, 18) from each other inside the accumulator housing (10), and which accumulator housing is sealed on each of the end sides by a cover component (20, 22), characterized in that on one side (40) of the cover component (20, 22) such cover component is fastened by way of the free longitudinal edge (32) of the accumulator housing (10), which for this purpose undergoes a positioning movement onto the cover component (20, 22).
2. The method as claimed in claim 1, wherein one side (36) opposite one side (40) of at least one of the two cover components (20, 22) is inserted into the accumulator housing (10) so as to come to rest against a stop (38) and/or wherein the respective cover component (20, 22) is retained in its end position by the clamping force of the positioned free longitudinal edge (32).
3. The method as claimed in claim 1 or 2, wherein a shaping tool (42) is provided for the positioning movement of the longitudinal edge (32) of the accumulator housing (10), which shaping tool (42) which positions the longitudinal edge (32) provided with least one positioning bevel (44) on the cover component (20) in such a way that this cover component (20) is secured in the accumulator housing (10) as a kind of clamping seat.
4. The method as claimed in one of claims 1 to 3, wherein the wall thickness of the longitudinal edge (32) is reduced in relation to that of the remainder of the accumulator

housing (10) and wherein the point of transition between the different wall thicknesses forms the stop (38) for the cover component (20) inside the accumulator housing (10).

5. The method as claimed in one of claims 1 to 4, wherein the longitudinal edge (32) is provided with an insertion bevel (50) on its side facing the respective cover component (20, 22) and toward the exterior.
6. The method as claimed in one of claims 1 to 5, wherein there is provided on the opposite side (40) of the cover component (20, 22) a contact surface (46), in particular in the form of a securing bevel against which the longitudinal edge (32) rests in the secured state and wherein the cover component (20, 22) closes off the accumulator housing (10) from the exterior.
7. The method as claimed in one of claims 3 to 6, wherein two shaping tools (42) in a joint positioning movement execute the securing process for the respective cover component (20, 22) on opposite sides of the accumulator housing (10) by acting on the respective free longitudinal edge (32) of the accumulator housing (10).
8. The method as claimed in one of claims 1 to 7, wherein the cover component (20, 22) is introduced into the accumulator housing (10) up to the stop (38) by means of a feed bevel (58), by means of a positioning tool (56) which encloses the free longitudinal edge (32) of the accumulator housing (10).
9. The method as claimed in one of claims 1 to 7, wherein the longitudinal edge (32) is provided on the internal circumference side with an insertion bevel (50) widening toward the exterior for the cover component (20, 22).

10. The method as claimed in one of claims 1 to 9, wherein the height selected for the cover component (20, 22) is at least twice as great as the free longitudinal edge (38) of the accumulator housing (10) introduced for the purpose of clamping the cover component (20, 22).